



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D4436-045
Job Sheet 187234



Part No: D4436-045

Job Qty: 6 ea

Part Name: Aft Inboard Bracket Assembly



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 11/29/18

Job Tracking No:

Due Date: 12/18/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: D4436 REV.B IPP revA 11.10.06 new issue EC verified by:DD IPP RevB 11.12.22 per PA2 EC verified by:JLM
IPP REV:C 12.01.24 PER DWG REV.A DD VERF:EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Waterjet - Flow - 1	6 pcs		12/13/18	0.00	1.07	Waterjet - Flow		SC 18/12/19
110	QC	6 pcs		12/13/18	0.00	0.00	QC2 Waterjet-3		SC 18/12/19
120	QC	6 pcs		12/13/18	0.00	0.00	QC8-4		DAS 38
125	Small Fab	6 pcs		12/13/18	0.00	1.17	Small Fab-6		38 9-89 DAS
130	Brake NC	6 pcs		12/13/18	0.08	0.83	Brake NC 2		9-89 DAS 38
150	QC	6 pcs		12/13/18	0.00	0.00	QC5		38 9-89
160	HandFinish	6 pcs		12/13/18	0.00	0.52	HandFinish1		7-89
170	QC	6 pcs		12/13/18	0.00	0.00	QC7-3		SMB
180	Small Fab	6 pcs		12/13/18	0.00	1.17	Small Fab-6		SMB
185	QC	6 pcs		12/13/18	0.00	0.00	QC5		DEC 18-12-20
190	Powdercoat	6 pcs		12/13/18	0.00	0.30	Powdercoat4		DEC 18-12-20
200	QC	6 pcs		12/13/18	0.00	0.00	QC3		58 DAS
202	Small Fab	6 pcs		12/13/18	0.00	1.17	Small Fab-6		9-89 58 DAS
205	QC	6 pcs		12/13/18	0.00	0.00	QC5		9-89 38
210	Packaging	6 pcs		12/13/18	0.00	0.00	Packaging3-2		DEC 20 2018 9-89
220	QC21-SA	6 Ea		12/13/18	0.00	0.00	QC21		DEC 21 2018

Part Op 100 - 1-Cut D4436-3 as per Dwg Dwg Rev: B Prog Rev: B 2-Deburr if necessary

Descriptions: 125 - 1- Transfer drill holes as per dwg. 2-C"SINK AS PER DWG 3-TRANSFER 0.129 HOLES THRU (2 PLACES)

180 - Assemble as per dwg. do not install grommets and rubber seal.

190 - START TIME: 9:10 OVEN TEMPERATURE: 300° FINISH TIME: 9:40

202 - Cut qty 1 to 3.8" Cut qty 1 to 10.00" Install rubber seals and grommets, as per dwg

M138559.

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M6061T6S.040	6061-T6 .040 Sheet	4.1340 sf (.689 ea)	100-Waterjet - Flow - 1	5120884
MS20426AD3-23	Rivet	24 Ea (4 ea)	180-Small Fab	5018535
MS20470AD4-34	Rivet, Universal Head	12 Ea (2 ea)	180-Small Fab	5106821
MS21075L08	Anchor Nut	12 Ea (2 ea)	180-Small Fab	5123462
D4441-1	Rubber Seal	6.9000 ft (1.15 ea)	202-Small Fab	5092167
MS35489-19	Grommet	6 Ea (1 ea)	202-Small Fab	5067899

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐		DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date :						MRB (QSI042)	
						Completed By	
						Lead hand / Supervisor	
						QC / QA Coordinator	
Manufacturing Process ☐ Equip/Tooling ☐ Handling/Presservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		Cracking ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐		Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐		RY ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread	
Other/Details: _____ _____ _____							

DART Aerospace Ltd.
 1270 Aberdeen Street
 Hamlet, ON K8A 1K7
 CANADA
 TEL: 1-813-832-5200
 Email: sales@dartaero.com
 www.dartaerospace.com



Container No: S135845



Part: D4436 - 045

Job No: 187234

Serial No/Batch: S135845

Revision: B

Inspector:

Exp Date:

Instructions: Various STC's

Date: 12/09/18

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Waterjet - Flow - 1 180-Small Fab	M6061T6S.040	4	220	0
	MS20426AD3-2	24	18,539	0
	MS20470AD4-3	12	4,841	0
	MS21075L08	12	119	0
202-Small Fab	D4441-1	7	535	0
	MS35489-19	6	84	0

Part Specifications

Specifications could not be found.

Plex 11/29/18 9:53 AM Dart.lajeunesse.marie

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐		DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐																															
Date : _____		Sequence #: _____		QTY Affected : _____		MRB (QSI042)																													
Description Work Order Deviation				Disposition																															
				Completed By																															
				Lead hand / Supervisor																															
				QC / QA Coordinator																															
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Presservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY <table border="0"><tr><td>☐ Pressure/Forced</td><td>☐ Contamination</td><td>☐ Power Loss/Surge</td><td>☐ Positioned Wrong</td></tr><tr><td>☐ Bending</td><td>☐ Misaligned/off center</td><td>☐ Folio/Program</td><td>☐ Outside Tolerance</td></tr><tr><td>☐ Crushing</td><td>☐ BOM/Route</td><td>☐ Grain Direction</td><td>☐ Drawing</td></tr><tr><td>☐ Cracks</td><td>☐ Broken/Damage/Defect</td><td>☐ Weld</td><td>☐ Finish</td></tr><tr><td>☐ Crimp/Kink/Ripple/Wave/Twist</td><td>☐ Incomplete/Unclear Instructions</td><td>☐ Wrong Stock Pulled</td><td>☐ Part Lost/Missing</td></tr><tr><td>☐ Marks/Chatter</td><td>☐ Drill Holes</td><td>☐ Out of Sequence</td><td>☐ Misread</td></tr><tr><td>☐ Mislabeled</td><td>☐ Fit/Function</td><td>☐ Off-set/Set-up</td><td></td></tr></table>						☐ Pressure/Forced	☐ Contamination	☐ Power Loss/Surge	☐ Positioned Wrong	☐ Bending	☐ Misaligned/off center	☐ Folio/Program	☐ Outside Tolerance	☐ Crushing	☐ BOM/Route	☐ Grain Direction	☐ Drawing	☐ Cracks	☐ Broken/Damage/Defect	☐ Weld	☐ Finish	☐ Crimp/Kink/Ripple/Wave/Twist	☐ Incomplete/Unclear Instructions	☐ Wrong Stock Pulled	☐ Part Lost/Missing	☐ Marks/Chatter	☐ Drill Holes	☐ Out of Sequence	☐ Misread	☐ Mislabeled	☐ Fit/Function	☐ Off-set/Set-up	
☐ Pressure/Forced	☐ Contamination	☐ Power Loss/Surge	☐ Positioned Wrong																																
☐ Bending	☐ Misaligned/off center	☐ Folio/Program	☐ Outside Tolerance																																
☐ Crushing	☐ BOM/Route	☐ Grain Direction	☐ Drawing																																
☐ Cracks	☐ Broken/Damage/Defect	☐ Weld	☐ Finish																																
☐ Crimp/Kink/Ripple/Wave/Twist	☐ Incomplete/Unclear Instructions	☐ Wrong Stock Pulled	☐ Part Lost/Missing																																
☐ Marks/Chatter	☐ Drill Holes	☐ Out of Sequence	☐ Misread																																
☐ Mislabeled	☐ Fit/Function	☐ Off-set/Set-up																																	
Other/Details: 																																			

DART AEROSPACE LTD	Work Order:	187234
Description: Aft Bracket Inboard Assembly	Part Number:	D4436-045
Inspection Dwg: D4436 Rev: A		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

[illegible]

Measured by: <u>SL</u>		Audited by: <u>35</u> <u>9-89</u>		Preliminary Approval:		
Date: <u>18/12/09</u>		Date: <u>DEC 11 2018</u>		Date:		
Rev	Date	Change			Revised by	Approved
A	15.10.14	New Issue			KJ <u>[Signature]</u>	<u>[Signature]</u>

